

Soudotec **FC 8271G** DC+**Cr - Mo STEEL****DESCRIPTION**

Low alloy chrome-molybdenum, gas shielded flux-cored wire with slag, for welding low alloy steels and carbon steels. Specifically recommended for welding steel containing 2.25% Cr - 1% Mo and similar grades.

**CHARACTERISTICS**

- Excellent all-position weldability
- Service temperature up to 550°C (1022°F)
- Good elongation
- Excellent machinability
- Stable arc and low spatter
- Easy to remove slag

**TYPICAL APPLICATIONS**

Alloy steel with chrome-molybdenum of the 4000 series (AISI), construction steel, tubes, motorcycle parts, molds and dies, etc.

**PROCEDURE**

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal with the Soudotec 212 SP or Soudotec G12 electrode. Remove slag between each pass. Let cool slowly. For medium carbon steels and on thick sections, preheating is recommended.

**MECHANICAL PROPERTIES**

Tensile strength:	95 000 psi (655 MPa)
Yield strength:	65 300 psi (450 MPa)
Elongation:	22 - 26 %

**WELDING PARAMETERS**

Gas:	Ar/CO <sub>2</sub> mixture or 100% CO <sub>2</sub>	
Diameter:	.045" (1.2 mm)	1/16" (1.6 mm)
Amperage:	150 - 330 A	150 - 410 A
Voltage:	21 - 29 V	21 - 25 V
Stick-out:	½" - 5/8"	½" - ¾"
Gas flow rate (c.f.h.):	40 - 50	40 - 50
Packaging:	11.4 kg spool	

Electrodes also available: Soudotec 271

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*Specialized welding alloys and technology. For technical assistance or for ordering:*



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